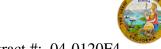
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-015325 Address: 333 Burma Road **Date Inspected:** 01-Jul-2010

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Mr. Xu Le Feng/ Mr. Qiu Wen **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** Tower

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay no. 11

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 219269 perform SMAW Tack welding on; East shaft, Lift 5, between Transverse diaphragm plate and Grillage plate and the weld joint is identified as ESD1-TL5-2 F/F-12A. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U5B. (Photo attached)

- 2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040611 perform SMAW welding on; Spare strut Flange to stiffener and the weld joint is identified as SD1-STSA4-5-139mtr.-1-33, 34. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2112. (Photo attached)
- 3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040655 perform SMAW welding on; Spare strut Flange to stiffener and the weld joint is identified as SD1-STSA4-5-139mtr.-1-45, 46. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2112.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040704 perform SMAW welding on; Lift 4 to 5, interior splice plate and the weld joint is identified as WSD1-SPSA5-12-1A. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U5B-1.

5. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040709 perform SMAW welding on; Lift 4 to 5, interior splice plate and the weld joint is identified as ESD1-SPSA5-7-2A. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U5B-1

6. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040614 perform SMAW welding on; Lift 4 to 5, interior splice plate and the weld joint is identified as ESD1-SPSA5-12-1A. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U5B-1.

Tower Jetty

7. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040582 perform SMAW Repair welding on; Cross bracing connecting plate in North shaft, Lift 2 at Tower trial assembly area in 65 mtr. elevation and the weld joint is identified as NSD1-SA 166 C/F-11, 13. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-485-SMAW-2G (2F)-Repair-1. The CWR report no. found to be T-CWR-650 & T-CWR-653.

8. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 202100 perform SMAW welding on; Cross bracing connecting plate in West shaft, Lift 2 at Tower trial assembly area in 77 mtr. elevation and the weld joint is identified as WSD1-SA 340 C/F-15. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3212-B-U2A-2.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)





Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By:	Baskar,Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer